

Work Order ID 73527

Thursday, September 01, 2011 2:43:28 PM



Item ID: D3910-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 9/1/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	B								

100

0.00



Bandsaw

Memo

0.00

Jcaspa Bandsaw

CUT BLANK 1.450" LONG

Cut @ meter

CZ11/09/01

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: _____

DWG REV: _____

issue Photo meter

DEBURR

P/D: 14799

CZ11/09/01 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120 rectl

QC2 Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

all'd inspect for transit damage
attached c/c to w/o

130

QC3 Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Sub 6/12

counters

(X30)

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

30 BK 11-9-13.

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Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

Powder Coating

M117745

0.00

Start Time: 2:30
Temp: 320°F
Finish Time: 3:00

30X of M-L 11/09/13

160

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

30 counted of M 11/09/13

170

Identify as per dwg & Stock Location: ST507

0.00



Packaging

Memo

Packaging

0.00

30X

11-09-14

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Tooling:

Date:

Run Start

QC: Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

n/a/14

CL11109114

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Picklist Print

Thursday, September 01, 2011 2:43:25 PM

Page 1

Work Order ID: 73527

Parent Item: D3910-1

Parent Item Name: Crosstube Lug



Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	538.5000	0.13	4.105263			



Lug Extrusion



CD 11/09/10

Location

Loc Qty

Loc Code

MAT006

538.5

43722

161.5

45800

1

68331

376

4.11

D3910-1 P

X 30

9/4/12 (30)

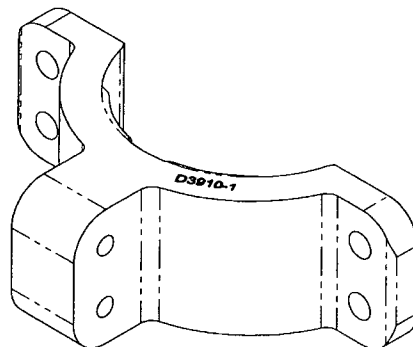
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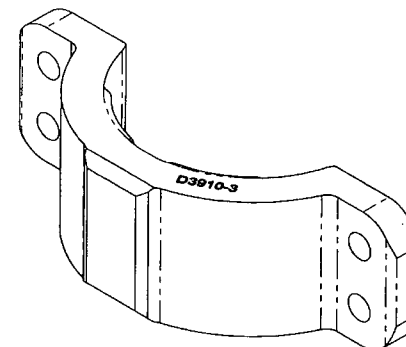
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D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

W/073527

RELEASED
2010-03-22
MD

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3) REASON: SEE TR-D390-807-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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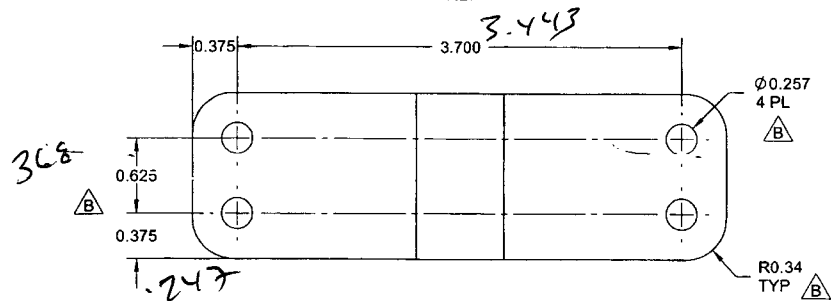
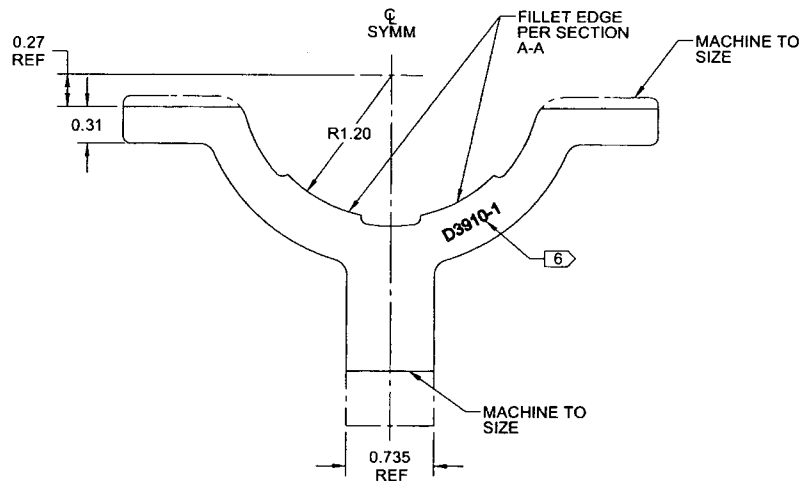
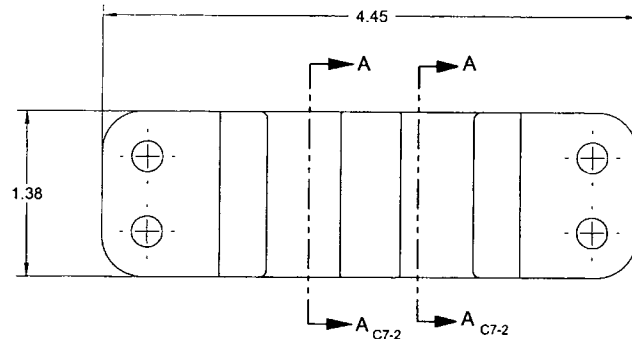
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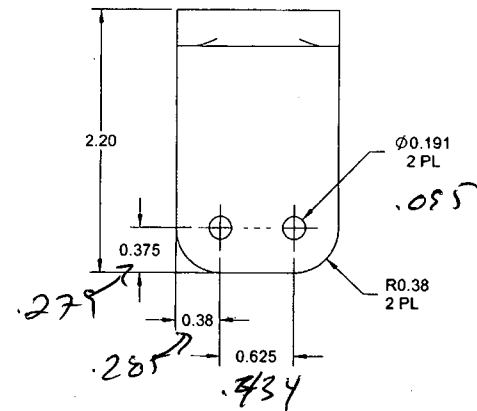


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



D3910-1 X-TUBE LUG



RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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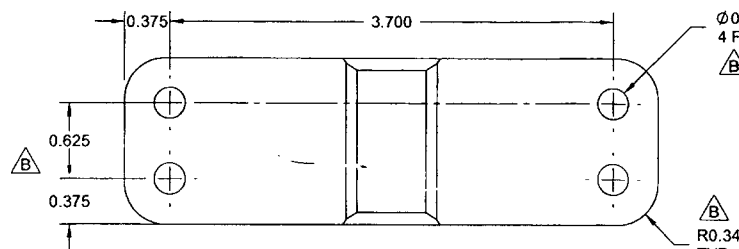
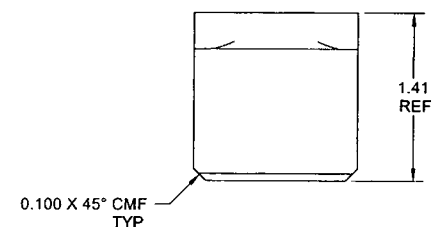
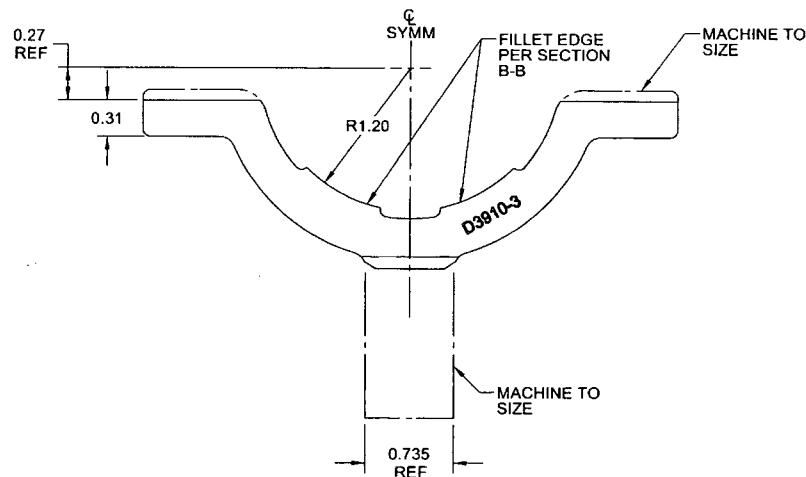
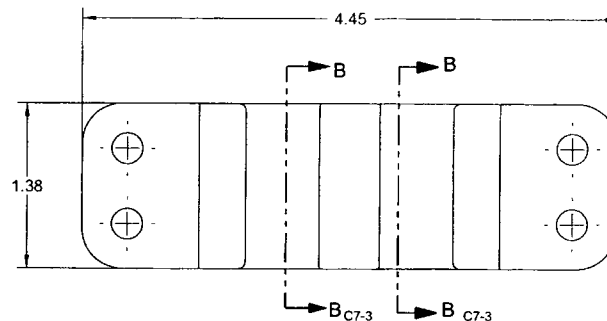
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

Ø0.257
4 PL
B

B
R0.34
TYP

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.:

Date:

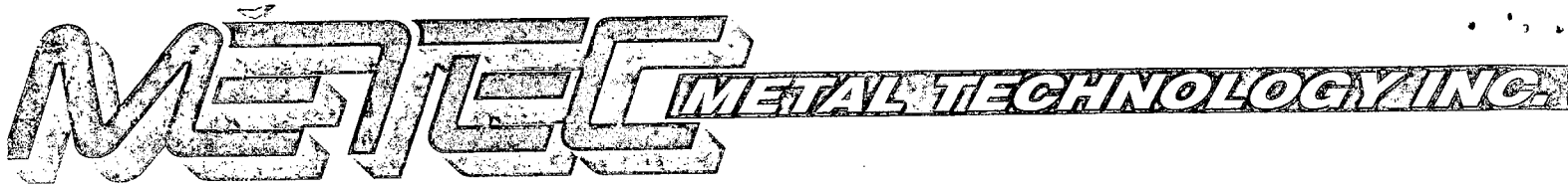
Sep 12, 2011

Page:

1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14799	Sold By: Walz, Christian D.
Shipped By:	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-3 Mounting Lug Material supplied by DART: D2423 B68331	Each	80		80
D2230-1 Mounting Lug Material supplied by DART: D2423 B68331	Each	100		100
D2230-3 Mounting Lug Material supplied by DART: D2423 B68331	Each	200		200
D3235-1 Mounting Lug Material supplied by DART: D2423 B68331	Each	100		100
D3394-1 Lug Assembly Material supplied by DART: D2423 B68331	Each	40	40	
D3910-1 Crosstube Lug Material supplied by DART: D2423 B68331	Each	30	30	
3910-3 Crosstube Lug Material supplied by DART: D2423 B68331	Each	30	30	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3394-1P	Lug	14799
30	D3910-1P	CROSS TUBE LUG	14799
30	D3910-3P	CROSS TUBE LUG	14799

MATERIAL: supplied by DART D2423 B63005

8/11/12

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, Sept. 12, 2011